



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4034-041
Job Sheet 188245



Part No: D4034-041

Job Qty: 4 pcs

Part Name: Aft Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA
10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER
DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/18/19	1/18/19	0.00	0.00	Start Up Large Fab 6		
100	Large Fab - Basket - 1	4 pcs	1/18/19	1/18/19	0.00	4.60	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		LL
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	4 pcs	1/18/19	1/18/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		PC
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	1/18/19	1/18/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		PC
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		

				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
130	Packaging 3-1 - Stock - B4B 4 pcs	1/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA 4 pcs	1/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	

CPL

DAS
21
D-RE

JAN 24 2019

Part Op **100** - (Weld per dwg A/R S.S. rod Batch: 135340) 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld
 Descriptions: bushing in rib and grind weld flush as per dwg
110 - (QC9- Inspect visual per QSI004- Fusion Welds)
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA004
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 pcs (1 ea)	90-Start up Operation	5144 786
D4021-9	Bushing	16 pcs (4 ea)	90-Start up Operation	5142 1870
D4034-1	Rib	4 pcs (1 ea)	90-Start up Operation	5142 791
D4034-3	Rib	4 pcs (1 ea)	90-Start up Operation	5143 222

1515312
2x

007712

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4021-7	4	18	0
	D4021-9	16	319	0
	D4034-1	4	17	0
	D4034-3	4	13	0
Part Specifications				
Specifications could not be found.				

Plex 1/22/19 8:23 AM Dart.Hadley.Shannon



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Part No: D4034-041

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Part Name: Aft Upper Rib Assembly



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Status: New

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Job Created: 1/4/19

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/18/19	1/18/19	0.00	0.00	Start Up Large Fab-6		
100	Large Fab	4 pcs	1/18/19	1/18/19	0.00	4.60	Large Fab 1		
110	QC	4 pcs	1/18/19	1/18/19	0.00	0.00	QC9		
120	QC	4 pcs	1/18/19	1/18/19	0.00	0.00	QC5		
130	Packaging	4 pcs	1/18/19	1/18/19	0.00	0.00	Packaging3 Large Fab		
140	QC21-SA	4 Ea	1/18/19	1/18/19	0.00	0.00	QC21		

Part Op 100 - 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld bushing in rib and grind weld flush as per dwg
Descriptions: 130 - LOCATION: WA004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 pcs (1 ea)	90-Start up Operation	
D4021-9	Bushing	16 pcs (4 ea)	90-Start up Operation	
D4034-1	Rib	4 pcs (1 ea)	90-Start up Operation	
D4034-3	Rib	4 pcs (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4021-7	4	15	0
	D4021-9	16	415	0
	D4034-1	4	12	0
	D4034-3	4	8	0

Part Specifications

Specifications could not be found.

Plex 1/4/19 1:10 PM Dart.lajeunesse.marie

LFC

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐
Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐														
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐														
Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐														
Date :	Sequence #:	QTY Affected :		MRB (QSI042)													
Description Work Order Deviation			Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator												

DART AEROSPACE
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 CANADA
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Container No: S147669
Part: D4034-041
Job No: 188245
Serial No/Batch: S147669
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 01/24/19

CATEGORY

☐ Power Loss/Surge	☐ Positioned Wrong
☐ Folio/Program	☐ Outside Tolerance
☐ Grain Direction	☐ Drawing
☐ Weld	☐ Finish
☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Out of Sequence	☐ Misread
☐ Off-set/Set-up	